ABSTRACT OF THE DISCLOSURE

In the present invention an image-forming production system includes a marking engine. The marking engine outputs a plurality of printed sheets at a first speed. An inserter is connected to receive the plurality of printed sheets from the marking engine and insert an insert sheet fed at a second speed. The inserter control board transmits synch pulse signals to an inserter speed adjust unit controller when a plurality of sheets approach the inserter speed adjust unit. The inserter speed adjust unit transmits a signal to the inserter speed adjust unit controller indicating an arrival of each of the plurality of sheets. The inserter speed adjust unit controller compares the measured arrival time with the synch pulse signal to adjust a speed of the plurality of sheets and the insert sheet to a third output speed.